

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LOWER BLADE SUPPORT AND COVER ASSEMBLY
Job Number	: 41371		
Estimate Number	: 13521		
P.O. Number	:	Part Number	: PB674300123
This Issue	: 18/08/2008 S.O. No. :	Drawing Number	: B6743001 P.10
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 41293	Material	:
Written By	:	Due Date	: 18/09/2008
Checked & Approved By	: <u>TW008.8.18</u>	Qty:	<u>8</u> Um: Each
Comment	: Est Rev:A 08-07-25 new issue DD verified by:ec		

Job Number:

1.0	MS27039110	Screw
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Screw

batch:

2.0 NAS1149F0316P WASHER

WASHER

batch:

3.0 PB674300179 Lower Blade Support Assy

Lower Blade Support Ass'y

batch:

4.0 PB674300183 PB67-43001-83

PB67-43001-83

batch:

5.0 PB6743001181 Cover Plate

Cover Plate

batch:

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:45:26 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOWER BLADE SUPPORT AND COVER ASSEMBLY

Job Number: 41371

Part Number: PB674300123

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



8X

Comment: Assemble as per dwg PB67-43001

M. J. F. 08/10/21

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/22 (X8)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



8X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5/16*

08/10/22

50

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/22 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MK- 08-10-22

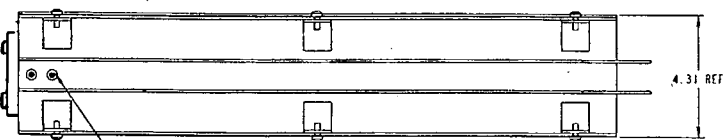
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-23 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 08/10/21
 QA: N/C Closed: _____ Date: _____

NCR: <u>41371</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>6/10/21</u>	<u>6.0</u>	<u>2 holes were drilled in wrong location. RC employee pulled</u>	<u>[Signature]</u>	<u>leave hole in and Re Drive hole in correct location.</u>	<u>[Signature]</u> <u>08/10/21</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>
		<u>wrong Part with out knowing</u>		<u>Touch-up seal the hole to prevent material fraying.</u>	<u>[Signature]</u> <u>08/10/21</u>	<u>[Signature]</u>		<u>08/10/21</u>

NOTE: Date & initial all entries

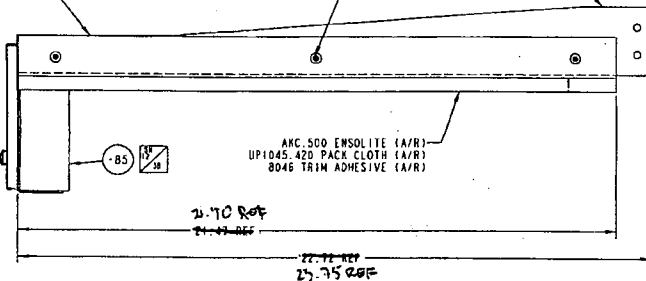


Ø .250 THRU -173
MATCH DRILL WITH HOLE
PATTERN OF -75
MS27039-1-10 SCREW
NAS1149F0316P WASHER
2 PLACES

MATCH DRILL COVER TO HOLES IN
ANGLE BRACKETS. ATTACH USING
MS27039-1-10 SCREW
NAS1149F0316P WASHER
6 PL 13 PL OPP

-173

-75



MS27039-1-10 SCREW
NAS1149F0316P WASHER
2 PLACES

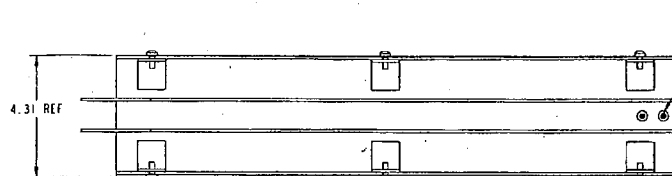
R1.75 REF



CUTOUT ENSOLITE FOR INTERFACING WITH -11 & -13 ASSEMBLIES

② -21 UPPER BLADE SUPPORT AND COVER ASSEMBLY

SCALE 0.500

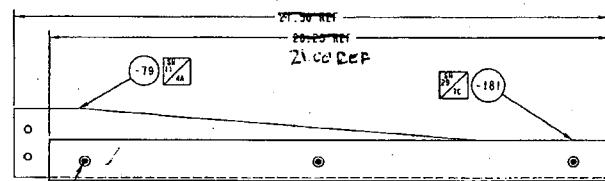


Ø .250 THRU -181
MATCH DRILL -181 WITH
EXISTING HOLE PATTERN
OF -79
MS27039-1-10 SCREW
NAS1149F0316P WASHER
2 PLACES

14.25 REF

21.30 REF

21.00 REF



MATCH DRILL HOLES IN COVER
TO ANGLE BRACKETS ON
SUPPORT. INSTALL COVER USING
MS27039-1-10 SCREW
NAS1149F0316P WASHER
6 PL 13 PL OPP

ANC 500 ENSOLITE (A/R)
UP1045 420 PACK CLOTH (A/R)
8046 TRIM ADHESIVE (A/R)

-83



CUTOUT ENSOLITE FOR INTERFACING WITH -15 & -17 ASSEMBLIES

② -23 LOWER BLADE SUPPORT AND COVER ASSEMBLY

SCALE 0.500

PREMIER AVIATION, INC.
2001 Aviation Parkway, Grand Prairie, Texas 75052
DATE: 01/01/88
DRAWN BY: D10SUV8
CHECKED BY: B67-43001
SCALE: 10:1
SHEET: 15

ORIGINAL

WITHOUT NOTICE
WORK ORDER
NO. 41371
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT